

ABSTRACT OF THE DISCLOSURE

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A drill string for a rotary-vibratory drill comprises a plurality of drill pipes. Each of the  
drill pipes has a longitudinal axis and at least one end. A female connector member and  
5 a male connector member are between the ends of adjacent said drill pipes, the female  
connector member having a first portion mating with a first of the adjacent drill pipes and  
a second portion extending away from the first of the drill pipes. The male connector  
member has a first portion mating with a second of the adjacent drill pipes and a second  
portion extending away from the second of the drill pipes, the second portion of the  
10 female connector threadedly engaging the second portion of the male connector. One of  
said each drill pipe and the connectors has a plurality of spaced-apart slots adjacent to the  
end of the drill pipe and communicating outwardly at the end. The slots are parallel to the  
longitudinal axis. Each of the connectors is connected to one of the adjacent drill pipes  
by welding extending about an adjacent said end of the one drill pipe and along the slots.

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